

Work Order ID 71090

Wednesday, June 22, 2011 11:15:57 AM



Page 1

Item ID: D4403-1

Accept



Setup Start



Revision ID:

Stop



Item Name: Fwd Bracket, LH

Start Date: 6/22/2011 Start Qty: 2.00



Cust Item ID:

Required Date: 6/30/2011 Req'd Qty: 2.00



Customer:

Reference:

11-06-22

Run Start



Approvals:

Process Plan:

Date:

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #
Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr	Revision Nbr
D4403	A

100

Cut blanks as per folio

0.00



Bandsaw

Memo

0.00

Jeaspa Bandsaw

CUT BLANK AT 7.625"

and 11/06/23

2 8

110

0.00



HAAS 1

Memo

0.00

HAAS CNC vertical machine #1

MACHINE AS PER DWG & FOLIO FB058

FOLIO REV: *AA*

DWG REV: *A*

and 11/06/24

2 8

DEBURR

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Page 2

Item ID: D4403-1

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Start Date: 6/22/2011 Start Qty: 2.00

Required Date: 6/30/2011 Req'd Qty: 2.00

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

120

QC2- Inspect parts off machine FAI/FAIB

0.00

OK 11/06/24



QC

Memo

0.00

Quality Control

2 0

130

QC8- Inspect parts - second check

0.00

OK 11/06/24



QC

Memo

0.00

Quality Control

2 0

140

Chemical Conversion Coat per QSI005 4.1

0.00

Ac 11-06-24



HandFinish

Memo

0.00

Hand Finishing

2 0

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Page 3

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Start Date: 6/22/2011 Start Qty: 2.00

Cust Item ID:

Required Date: 6/30/2011 Req'd Qty: 2.00

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

150

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

10/6/24 2

160

Identify as per dwg & Stock Location: 100

0.00



Packaging

Memo

0.00

Packaging

11/5/24 2

170

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

11/06/2411.06.24

Picklist Print

Page 1

Wednesday, June 22, 2011 11:15:53 AM

Work Order ID: 71090



Parent Item: D4403-1



Parent Item Name: Fwd Bracket, LH

Start Date: 6/22/2011

Required Date: 6/30/2011

Start Qty: 2.00

Required Qty: 2.00

Comments: IPP REV:A NEW ISSUE 11/06/15 JFS VERIFY BY:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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M7075T73B01.250X03.
000

Purchased

No

100

f

9.6820

0.64

1.347368



7075-T73 BAR 1.250" X 3.000"

Location

Loc Qty

Loc Code

MAT008

9.682

117942

9.682

1.35 on 6/22/11

DART AEROSPACE LTD		Work Order: 71090
Description: FWD BRACKET, LH		Part Number: D4403-1
Inspection Dwg: D4403 Rev: A		Page 1 of 1

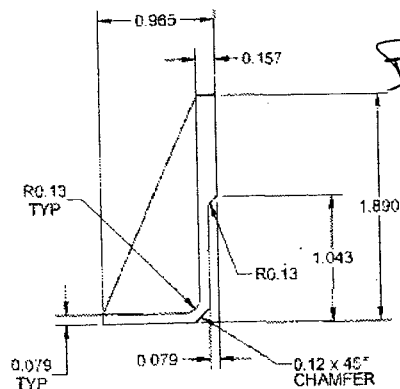
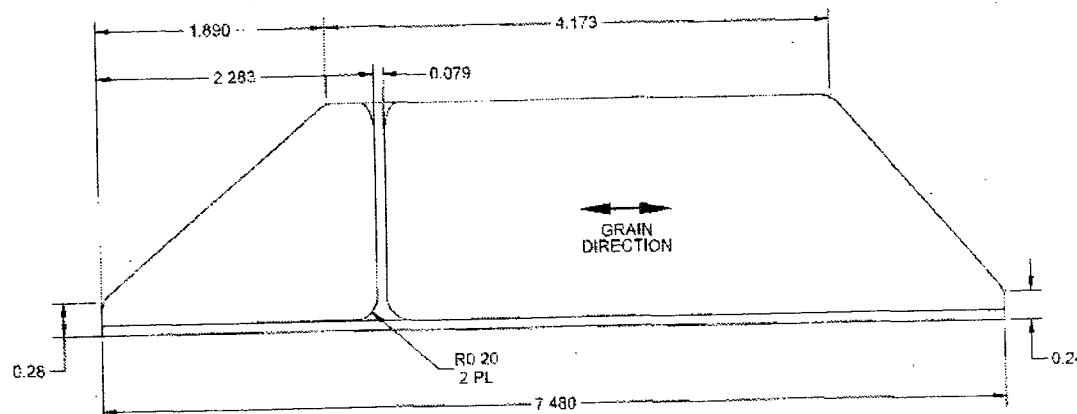
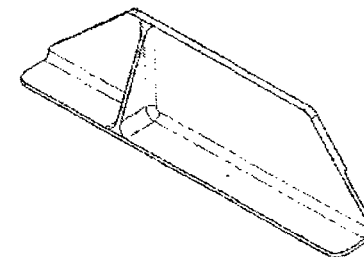
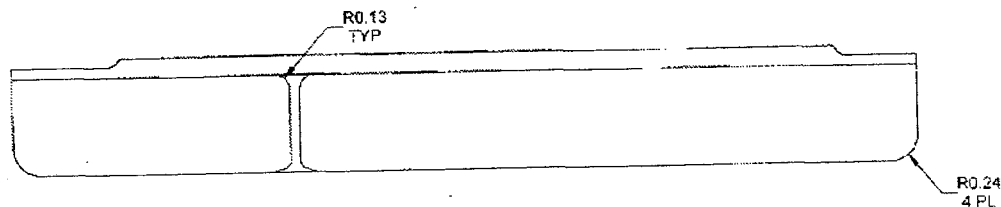
FIRST ARTICLE INSPECTION CHECKLIST

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
R.13	$\pm .030$	R.125	—		R-6	
R.25	$\pm .030$	R.250	—		"	
2.283	$\pm .010$	2.283	—		Vern	ML-7
.079	$\pm .010$.081	—		"	"
R.20	$\pm .030$	R.200	—		R-6	
7.480	$\pm .010$	7.482	—		Vern	ENL-02
.079	$\pm .010$.072	—		Vern	ML-7
.079	$\pm .010$.081	—		"	"
.12 X 45°	$\pm .030$.125 X 45°	—		"	"
R.13	$\pm .010$	R.125	—		R-6	
1.043	$\pm .010$	1.041	—		Vern	ML-7
1.890	$\pm .010$	1.891	—		"	"
.157	$\pm .010$.160	—		"	"
.965	$\pm .010$.965	—		"	"

Measured by: <i>mf</i>	Audited by: <i>DFB</i>	Preliminary Approval:
Date: 11/06/24	Date: 11/06/24	Date: <i>DF</i>

Rev	Date	Change	Revised by	Approved
E	10.04.14	Added preliminary approval	KJ	

10.04.15



B71090

D4403-1 FWD BRACKET, LH

NOTES:

- 1) MATERIAL: 7075-T7351 ALUMINUM BAR
AMS-QQ-A-250/12 (AMS 4078)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY PER QSI 044 6.1
- 7) WEIGHT: 0.18 lbs
- 8) SIMILAR TO AGUSTA P/N 3G2591A07051

RELEASED
2011-05-24

A		NEW ISSUE		RF	11.05.15	
REV.		DESCRIPTION			BY	DATE
DESIGN		RF	DART AEROSPACE LTD			
DRAWN		RF	HAWKESBURY, ONTARIO, CANADA			
CHECKED		#	DRAWING NO			REV. A
MFG. APPR.		#	D4403			SHEET 1 OF 1
APPROVED		#	TITLE			SCALE
DE APPR.		#	BRACKET			NTS
DATE		11.05.15	COPYRIGHT © 2011 BY DART AEROSPACE LTD			